

Work Order ID 58464

May 7, 2010 10:21:59 AM



Page 1

Item ID: D4037-1

Accept



Setup Start



Revision ID:

Item Name: Aft Crossbeam

Stop



Start Date: 07/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-5-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4037

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut blank as per file D4037-1_BLANK

B 10-5-12

(4)

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA877 AND DWG

FOLIO REV: *10*

DWG REV: *10*

DEBURR

10.5.20

Work Order ID 58464

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Page 3

Item ID: D4037-1

Accept



Setup Start



Revision ID:

Item Name: Aft Crossbeam

Stop



Start Date: 07/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

M114207
START: 2:15pm
TEMP: 320°F
FIN: 2:45pm

=) 10/05/25

X4

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

H BR 10-5-26.

170



Packaging

Packaging

Identify as per dwg & Stock Location: 196

0.00

Memo

0.00

10-5-26 SP (CN)

Picklist Print

May 7, 2010 10:22:03 AM

Page 1

Work Order ID: 58464



Parent Item: D4037-1



Parent Item Name: Aft Crossbeam

Start Date: 07/05/2010

Required Date: 14/05/2010

Comments: IPP REV:A NEW ISSUE 09-12-14 JLM VERIFIED BY:EC IPP
REV:B AS PER REV B 10-04-19 JLM VERIFIED BY:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M6061T6B1.000X15.00 0		Purchased	No			100	f	78.5000	3.9	15.6		



6061-T6 Bar 1.00 x 15.00



1310-5-12

Location

Loc Qty

Loc Code

MAT

72

114562

72

MAT07

6.5

9544

6.5

114562

4

DART AEROSPACE LTD		Work Order: 58464
Description: AFT CROSSBEAM		Part Number: D4037-1
Inspection Dwg:	Rev: 13	Page 1 of 12

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.38	+/- .030	1.378				
1.750	+/- .010	1.750				
.86	+/- .030	.858				
2.125	+/- .010	2.125				
2.250	+/- .010	2.250				
.875	+/- .010	.875				
.875	+/- .010	.875				
6.000	+/- .010	6.000				
1.125	+/- .010	1.125				
1.38	+/- .030	1.381				
6.00	+/- .030	6.00				
5.29	+/- .030	5.293				
R1.63	+/- .030	R1.63				
.316 Ø	+ .006 - .001	.316				
R.63	+/- .030	R.63				
.391 Ø	+ .006 - .001	.391				
R1.00	+/- .030	R1.00				
.38	+/- .030	.376				
7.750	+/- .030	7.754				
1.00	+/- .030	1.021				
8.04	+/- .030	8.048				
42.87	+/- .030	42.88				

Measured by: <i>af</i>	Audited by: <i>amh</i>	Prototype Approval:	N/A
Date: 10.5.21	Date: 10/05/23	Date:	N/A

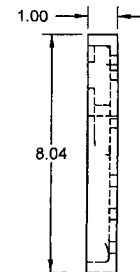
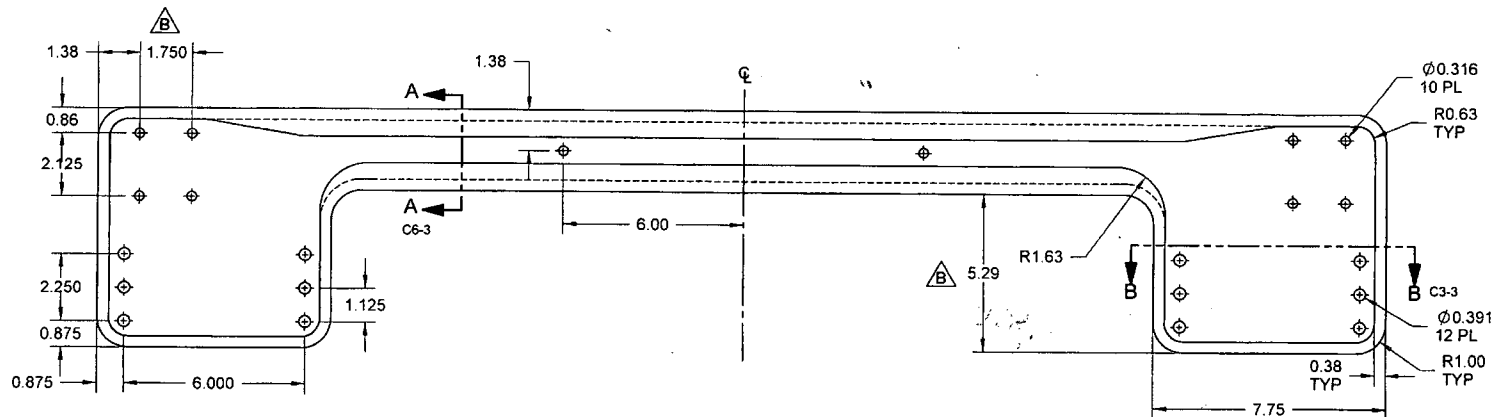
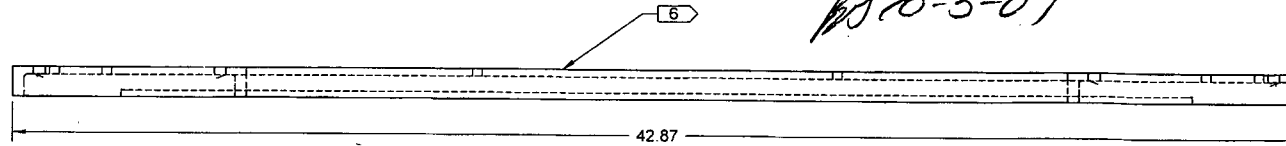
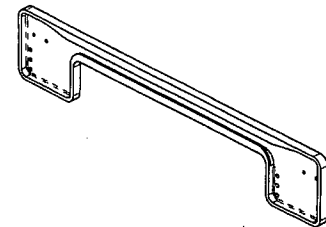
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 58464

10-5-07



D4037-1 AFT CROSSBEAM

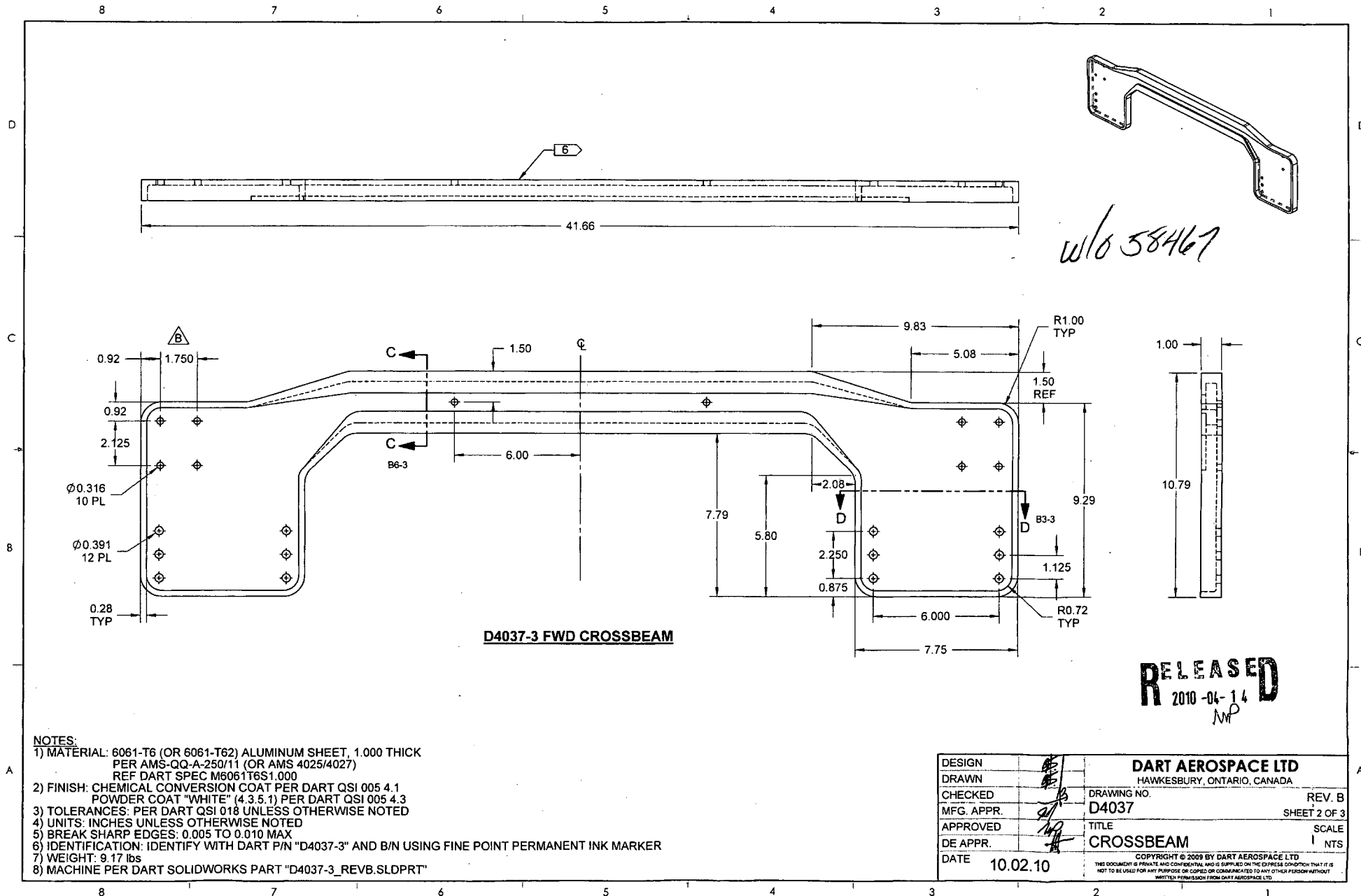
RELEASED
2010-04-14

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK
PER AMS-QQ-A-250/11 (OR AMS 4025/4027)
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4037-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 8.48 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4037-1_REV.B.SLDPRT"

B	ADJUST DIMS AND REPOSITION HOLES, ZN 84-1, C8-2	HS	10.02.10
A	NEW ISSUE	HS	09.12.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.10		

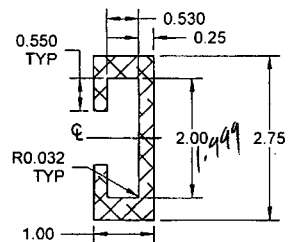
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DRAWING NO. D4037	REV. B
TITLE CROSSBEAM	SCALE NTS
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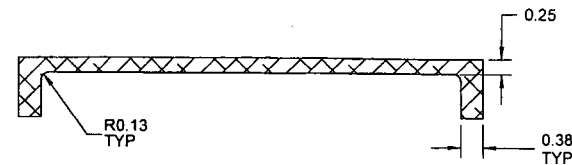
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REF DART SPEC M6061T6S1.000
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POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4037-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 9.17 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4037-3_REV.B.SLDPRT"

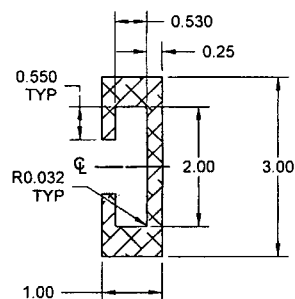
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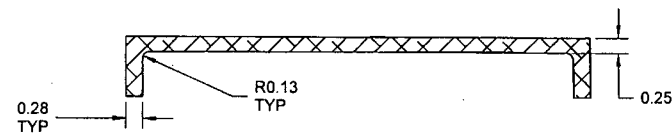
SECTION A-A B6-1
SCALE 2X



SECTION B-B B2-1
SCALE 2X



SECTION C-C B6-2
SCALE 2X



SECTION D-D B3-2
SCALE 2X

w/o 58464

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